






<b>E-Coat Panel Prep</b>		
<b>1</b>		<p><b>Cleaning</b></p> <p>Clean part with soap and water, followed by a VOC compliant surface cleaner.</p>
<b>2<sub>A</sub></b>		<p><b>Surface Prep Hand</b></p> <p>Sand edges and other hard to reach areas using P400 flexible abrasive sheet or Scotch-Brite™ hand pad until the surface is matte and all sheen has been removed.</p>
<b>2<sub>B</sub></b>		<p><b>Surface Prep Machine</b></p> <p>Sand remaining surfaces using P400 abrasive on a DA sander until the surface is matte and all sheen has been removed. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the e-coat surface.</b></p>
<b>3</b>		<p><b>Re-clean</b></p> <p>Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.</p>
<b>4</b>		<p><b>Apply Top Coats</b></p> <p>Seal and paint following paint company recommendations.</p>

**Product List**

3M™ Car Wash Soap Concentrate, 3.7L, PN 38377



3M™ All Purpose Cleaner and Degreaser Concentrate, 3.7L, PN 38350



3M™ Flexible Abrasive Hookit™ Sheets, P400, PN 34337



Scotch-Brite™ Durable Flex Hand Pads, Very Fine grade, 230mm x 115mm, PN 64649



3M™ Flexible Abrasive Hookit™ Foam Pad, PN 34349



3M™ Purple Clean Sanding Hookit™ Disc 334U, 150mm, P400, PN 01811



3M™ Accuspray™ ONE Spray Gun System with PPS™, PN 16578



**Think About Your Health**

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Face Welding Respirator Kit, PN 6228



3M™ Secure Fit™ 200 Series Anti-fog Eyewear, Clear Frame, PN 201AF-AS



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.